5/42

DART AEROSPACE LTD	Work Order:	24402
Description: 206 Step End Plate	Part Number:	D2734
Drawing: D2734 Rev. B	Qty:	23/200

Step	Location	Procedure	D.	Date	Qty	1
Step			By	Date	Qty	
1	EXPEDITING	Issue Work Order	b/1	85.10.03	200	
L		Check inventory of D2875, if low run at the same time	18	03,10,103	200	
2	METAL	Shear blanks: 3.035" +0.000/-0.010 X 2.90 +0.030/-0.010				
	}	Grain along 3.035"	1	1		
		5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11)	1	1	i	
	]	0.063 thick.	İ			
		Batch: M16~154	2/	05.10.2-1	2211	221
<del></del>	11440	<u> </u>	50-	05.10.2-1	469	T 2 1
4	HAAS	Machine per folio D2734				- 2
		Flat pattern is the same as D2875	ZV	05.10,24	75-	(マン)
5	QC	Inspect Level 2				
			121	05,10,24	374	231
6	QC	Inspect Level 8	-	5,70,27		
0	Q O	mapeet Level o	-21	05.10.24		921
<u> </u>	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		136	05.10.24	CCOL	1-7-2 /
8	METAL	Form per drawing D2734			" C C"	ŀ
			12	25.00.20	77/	
9	QC	Inspect Level 5			1	
			/	25.10.25	5.21	ŀ
10	STORES	Identify and stock		<del> </del>		1
'	0.01.20	lucinary and otook		05-10-25	231	[.
14	EVENTING	Class IMO	<u>//</u>			{
11	EXPEDITING	Close W/O	17	10-11-	122	
L		Cost/Part, 97 Suc 05/10/26 (231)	1-P	145/10/26	193/	
		198				

		• //	_	
Rev	Date		Created By	Approved
A	98.06.02		KB	
В	00.01.11	Added note at step one, level 2, re-format	EC	
С	00.05.19	Added inspect level 8, removed P/O for powder coating	EC	
D	01.06.08	Removed Deburr	EC	CC

RELEASED

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B	•	Varification	A	Annessal		
STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector		
			<b>\</b> .						
						!			
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP  Description of NC Section A  Initial Design Mgr  Design Mgr  Corrective Action Section B  Action Description Design Mgr	STEP Description of NC Section A Initial Design Mgr Design Mgr Design Mgr Date	STEP Description of NC Section A Initial Design Mgr Design Mgr Design Mgr Section B  Verification Section C	STEP Description of NC Section A Design Mgr Corrective Action Section B / Section C Se		

Part No:	PAR #:	Fault Category:NCR	R:	Yes No DQA:	Date: <u>65/6/</u> 39
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	24402
Description: End Plate	Part Number:	D2734
Inspection Dwg: D2734 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.900	+/-0.010	2.894				
3.035	+/-0.010	3.040				Barat.
			N.			
				_		
	·					
			,			
				-		
	7784					
					, , , , , , , , , , , , , , , , , , , ,	

Measured by:	21	,2	Audited by:	736	Prototype Approval:	N/A
Date:	G5.1	0.24	Date:	05.10-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM	(1111

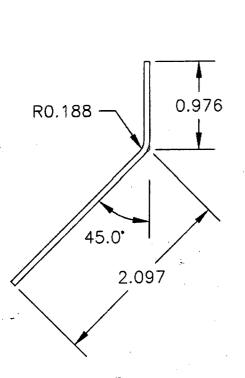
RELEASED



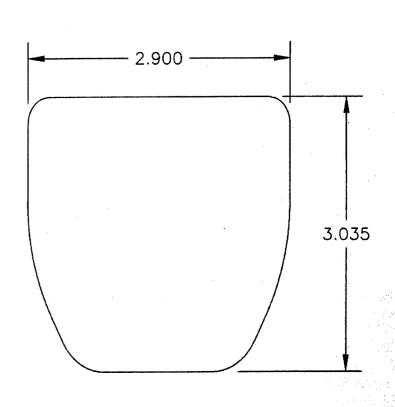


		,
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. REV. B
<i>PH</i>	13	D2734 SHEET 1 OF 1
DATE		TITLE SCALE
98.10.05		END PLATE 1:1
Α	97.12.10	NEW ISSUE
В	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137





BEND DETAIL



FLAT PATTERN

SHOF COPY

ENGINEERING

UNION TROLLED COPY

TITE AMENDMENT :

WORK ORDER NO. <u>24402</u>

MATERIAL: 5052-H32 (QQ-A-250/8) OR

6061-T6 (QQ-A-250/11) 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## Job Costing Report

Dart Aerospace Hawkesbury	Ltd.	JOD COSCING REPOIL	Oct 03, 2005 11:23 am
Work Order No Project Name Project For	: 0024402 : D2734 : WK542	Department Code Burden Flags	

Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D2734 Invoice Date :

Description: 206 Step Endplate Invoice Number:

Manufactured: Yes Invoice Amount: 0.00

Amount Req'd: 200 Amount Done: 0 Order Entry No:

Start Date : 10-03-05 OE Value : 0.00

Est Finish Date : 10-20-05

Act Finish Date : Est Mark Up : 0.000%

Drawings Regd : No Actual Mark Up : 0.000%

Drawings Reqd : No Ok for Approval :

Approval Rec'd : \$0 Posted to Finished Goods

		Estimated	Actual	۷ar. %	Posted	To Post
=======================================	===	========		=======	=========	=========
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
			========	======		
Burden	:	0.00	0.00	0.00		÷
		========	========	=======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000	•		
Selling Cost	:	0.00	0.00	•		

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00